

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 74.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010037**Date Inspected:** 02-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 745**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:****Contractor:** Goodwin Steel, UK**Location:** Stoke-on-Trent, UK

CWI Name:	N/A		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No
Weld Procedures Followed:	Yes	No
Verified Joint Fit-up:	Yes	No
Approved WPS:	Yes	No
Delayed / Cancelled:	Yes	No

Bridge No: 34-0006**Component:** Cable Band Castings**Summary of Items Observed:**

The following report is based on METS Caltrans QA Inspector Mike Brcic's observations at Goodwin Steel Castings, Stoke-on-Trent, England, UK on 2 November 2009.

REPAIR WELDING

* GG29441-2 (B10-2-F) Observed welder A.Migas, welder ID AM80, performing Shielded Metal Arc Welding (SMAW) process using 4mm, E7018-1 electrode, in a 1G position. Parameters of WPS 04-0120F4B issue 4 (casting repair cycle is classified as a Major), were verified and followed; actual Amp range during observation was 121 ~ 127, voltage 22~25. Temperatures of casting exceeded 170° Celsius (preheat 160°) and was below 399° Celsius for an interpass temperature (both values confirmed with temperature sticks). Excavation in work was identified as #2, on the Weld Excavation Map.

Unless otherwise noted, all observations reported on this date appeared to be in general compliance with applicable contract documents.

Summary of Conversations:

No significant conversations took place that this Inspector was a party to.

Comments

WELDING INSPECTION REPORT

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This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 1(510)385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Brcic,Michael	Quality Assurance Inspector
Reviewed By:	Edmondson,Fred	QA Reviewer
